

# Work Order ID 92082

Tuesday, October 23, 2012 4:07:41 PM

\*92082\*

Page 1

Item ID: PB67-43001-79

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Lower Blade Support Assembly

Stop \*NS2\*

Start Date: 10/23/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12-10-25 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

B67-43001-79

C

100

Weld per dwg A/R Aluminum rod Batch: 122399 0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg PB67-43001

9 0 12-11-20

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC

Memo

0.00

Quality Control

9 0 12-11-20

120

QC5- Inspect part completeness to step on W/O 0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS 15 12-11-20

9 0 12-11-20

DAS 18 12-11-20

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Item ID: PB67-43001-79 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Lower Blade Support Assembly  
 Start Date: 10/23/2012 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 11/2/2012 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3  Memo *** put screws in nut plates before to keep thread clean*** START TIME: 2:00 OVEN TEMPERATURE: 3200 F FINISH TIME: 2:30	0.00  0.00				9X			Mf 12/11/22
140 *140* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				9		12/11/22	259
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: ST 953 Memo	0.00  0.00							Chapman (9)

**Work Order ID 92082**

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**\*92082\***

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Item ID: PB67-43001-79      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Lower Blade Support Assembly  
Start Date: 10/23/2012      Start Qty: 10.00      **\*10\***      Cust Item ID:  
Required Date: 11/2/2012      Req'd Qty: 10.00      **\*10\***      Customer:  
Reference:

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_      Run Start **\*NR1\***  
                 QC: \_\_\_\_\_      Date: \_\_\_\_\_      SPC (Y/N): \_\_\_\_\_      Date: \_\_\_\_\_      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/11/2012 [Signature]  
11/2-26-12

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	

# Picklist Print

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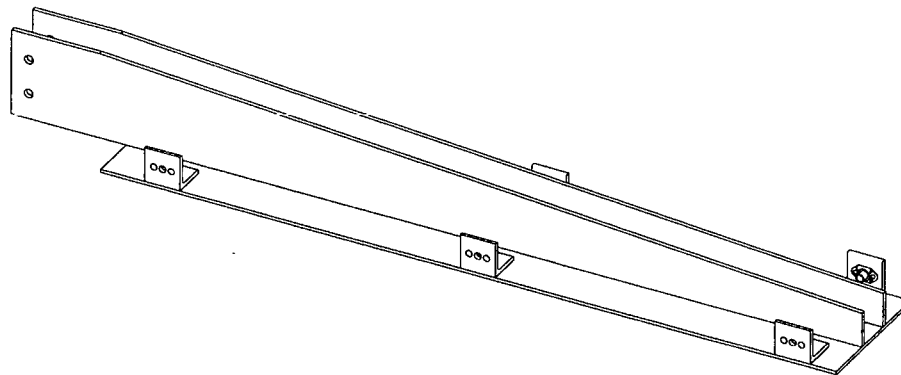
Work Order ID: 92082  
 Parent Item: PB67-43001-79  
 Parent Item Name: Lower Blade Support Assembly

Start Date: 10/23/2012 Required Date: 11/2/2012  
 Start Qty: 10.00 Required Qty: 10.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
→ PB67-43001-171 Mounting Plate		Manufactured	No			100	Each	18.0000	6	60		11/12/11/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA	390909	18				36/2			
					85118	18				18			
PB67-43001-177 Short Support Plate		Manufactured	No			100	Each	2.0000	1	10		11/12/11/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST443	90910	2				2			
					85121	2				2			
→ PB67-43001-179 Short Side Plate		Manufactured	No			100	Each	3.0000	2	20		11/12/11/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz	390911	1				15			
					52431	1				1			
				WA		2							
					85122	2				2			

ITEM	QTY -79	P/N	DESCRIPTION
1	X	B67-43001-79	LOWER BLADE SUPPORT ASSY
3	6	B67-43001-171	MOUNTING PLATE
4	1	B67-43001-177	SHORT SUPPORT PLATE
5	2	B67-43001-179	SHORT SIDE PLATE
7	12	MS20426AD3-4	RIVET
8	6	MS21075L3	NUT PLATE



**B67-43001-79 LOWER BLADE SUPPORT ASSY**

SHOP  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO MINOR  
WITH NO  
92082MLS  
12-10-25

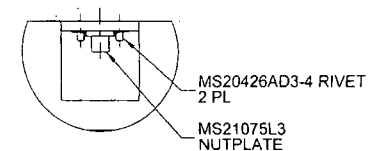
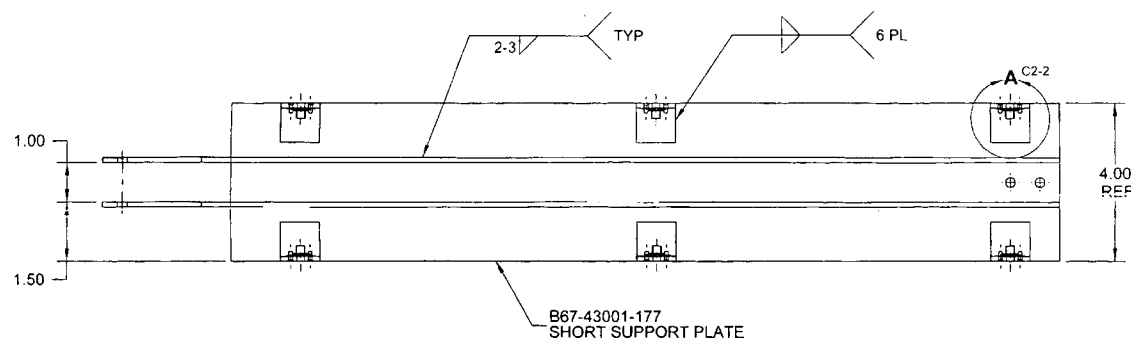
RELEASED  
2009-09-24  
MP

**NOTES:**

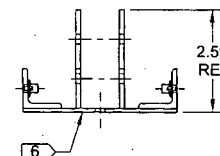
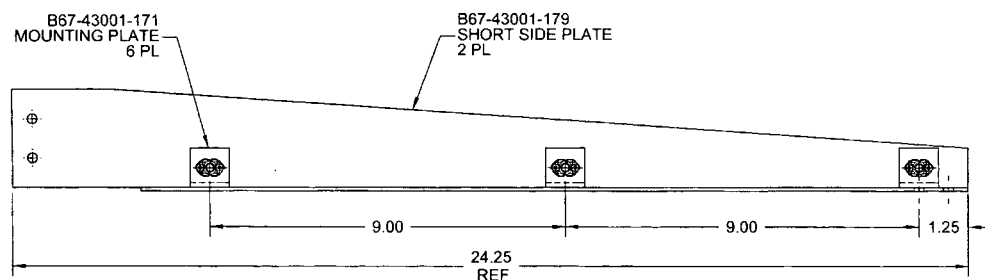
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREEN SANDEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-79" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.96 lbs
- 8) WELDING: PER DART QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.26
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. C SHEET 1 OF 2 SCALE NTS	
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.	N/A			
DATE	09.06.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

92082



**DETAIL A** C2-2  
SCALE 2X, 6 PL



**B67-43001-79 LOWER BLADE SUPPORT ASSY**

**RELEASED**  
2009-09-24  
MP

DESIGN	RW	<b>DART AEROSPACE LTD</b>	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	<b>B67-43001-79</b>	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	N/A	<b>LOWER BLADE SUPPORT ASSY</b>	NTS
DATE	09.06.26	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	